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<p>(54) Title: EXTRUSION COATING POLYESTER COMPOSITIONS</p> <p>(57) Abstract</p> <p>Solid extrusion coating compositions for metal substrates, a method of extrusion coating a metal substrate, and a metal article are disclosed. The extrusion coating composition is a thermoplastic material and comprises: (a) a first polyester having a weight average molecular weight of about 10,000 to about 80,000 and a T<sub>g</sub> of greater than 45 °C to about 100 °C; (b) a second polyester having a weight average molecular weight of about 10,000 to about 70,000 and a T<sub>g</sub> of about -10 °C to about 45 °C; and optionally, (c) a modifying resin, such as an epoxy resin having an epoxy equivalent weight of about 500 to about 15,000, wherein the T<sub>g</sub> of the first and second polyesters differ by about 5 °C to about 60 °C. The extrusion coating composition is applied to a metal substrate in an extrusion process to provide a composition film having a thickness of about 1 to about 40 microns.</p> <p style="text-align: right; font-size: 1.5em; font-weight: bold;">Best Available Copy</p>		

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## EXTRUSION COATING POLYESTER COMPOSITIONS

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FIELD OF THE INVENTION

The present invention relates to extrusion coating compositions for metal substrates that, after application, demonstrate excellent adhesion, weatherability, barrier properties, and flexibility;

15 to a method of extrusion coating a metal substrate; and to a metal article, such as a metal can or container, or a material of construction, such as aluminum siding, having at least one surface coated with an adherent layer of an extrusion coating com-

20 position. An extrusion coating composition comprises: (a) a first polyester having a weight average molecular weight of about 10,000 to about 80,000 and a glass transition temperature (T<sub>g</sub>) of greater than 45°C to about 100°C, (b) a second polyester

25 having a weight average molecular weight of about 10,000 to about 70,000 and a T<sub>g</sub> of about -10°C to about 45°C, and optionally, (c) a modifying resin, for example, an epoxy or phenoxy resin having an

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epoxy equivalent weight of about 500 to about 15,000, wherein the Tg of the first and second polyester differ by about 5C° to about 60C°. The extrusion coating composition is applied to a metal substrate as a film having a thickness of about 1 to about 40 microns.

### BACKGROUND OF THE INVENTION

It is well known that an aqueous solution in contact with an untreated metal substrate can result in corrosion of the untreated metal substrate. Therefore, a metal article, such as a metal container for a water-based product, like a food or beverage, is rendered corrosion resistant in order to retard or eliminate interactions between the water-based product and the metal article. Generally, corrosion resistance is imparted to the metal article, or to a metal substrate in general, by passivating the metal substrate, or by coating the metal substrate with a corrosion-inhibiting coating.

Investigators have sought improved coating compositions that reduce or eliminate corrosion of a metal article and that do not adversely affect an aqueous product packaged in the metal article. For example, investigators have sought to improve the imperviousness of the coating in order to prevent corrosion-causing ions, oxygen molecules, and water molecules from contacting and interacting with a metal substrate. Imperviousness can be improved by providing a thicker, more flexible, and more adhesive coating, but often, improving one advantageous

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property is achieved at the expense of a second advantageous property.

In addition, practical considerations limit the thickness, adhesive properties and flexibility of a coating applied to a metal substrate. For example, thick coatings are expensive, require a longer cure time, can be esthetically unpleasing, and can adversely affect the process of stamping and molding the coated metal substrate into a useful metal article. Similarly, the coating should be sufficiently flexible such that the continuity of the coating is not destroyed during stamping and molding of the metal substrate into the desired shape of the metal article.

Investigators also have sought coatings that possess chemical resistance in addition to corrosion inhibition. A useful coating for the interior of a metal container is able to withstand the solvating properties of a product packaged in the metal container. If the coating does not possess sufficient chemical resistance, components of the coating can be extracted into the packaged product and adversely affect the product. Even small amounts of extracted coating components can adversely affect sensitive products, such as beer, by imparting an off-taste to the product.

Conventionally, organic solvent-based coating compositions were used to provide cured coatings having excellent chemical resistance. Such solvent-based compositions include ingredients that are inherently water insoluble, and thereby effectively resist the solvating properties of

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water-based products packaged in the metal container. However, because of environmental and toxicological concerns, and in order to comply with increasingly strict governmental regulations, an increasing number of coating compositions are water based. The water-based coating compositions include ingredients that are water soluble or water dispersible, and, therefore, cured coatings resulting from water-based coating compositions often are more susceptible to the solvating properties of water.

In addition, water-based coating compositions do not completely overcome the environmental and toxicological problems associated with organic solvents because water-based compositions typically contain two or more pounds of organic solvent per gallon of coating composition. The organic solvent is a necessary ingredient to dissolve and disperse composition ingredients, and to improve the flow and viscosity of the composition. Therefore, in order to entirely avoid the environmental and toxicological problems associated with organic solvents, investigators have sought solid coating compositions that can be applied to a metal substrate. To date, investigators have had difficulty in providing a solid coating composition that matches a liquid coating composition with respect to film uniformity, film appearance, and film performance.

In prior attempts to find a useful solid coating composition, investigators have tested powder coatings, laminated film coatings, radiation cure coatings, and extrusion coatings. A great deal of research has been performed using free film lami-

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nates of polymers such as polyethylene terephthalate (PET), polypropylene (PP), and polyethylene (PE).

In this method, a preformed polymer film, about 10 to about 25 microns thick, is applied to the metal substrate. The film laminate method is a rapid method of coating a metal substrate, but the method is expensive and the coated metal substrate does not possess all of the properties required, or desired, by can, can end, and closure manufacturers.

10           Solid powder coatings also have been used to coat a metal substrate with a coating composition. However, the application of a thin, uniform coating to a metal substrate, i.e., less than 40 microns, is difficult to impossible using the powder coating method. Often, if a thin coating is applied to a metal substrate using a powder coating method, the coating has imperfections which cause the film to fail. Such failures are impermissible in the food and beverage container industry, which further require thin coatings that can withstand shaping of a flat, coated metal substrate into a can, can end, or closure.

25           Solid coating compositions also have been extruded onto a metal substrate, for example, as disclosed in European Patent No. 0 067 060, PCT publication WO 94/01224, Smith et al. U.S. Patent No. 5,407,702, and Jones et al. U.S. Patent No. 5,736,086. The extrusion coating of a solid composition onto a metal substrate is complicated by 30 the fact that the solid composition must be heated sufficiently to melt the composition for flow through the extrusion apparatus. The heating step

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either can alter the chemical make-up of the coating composition or can cause a premature cure of the coating composition, especially a thermoset composition, which changes the properties of the coating on the metal substrate or makes extrusion onto the metal substrate difficult due to crosslinking in the extruder. Either effect can adversely affect the performance of the composition coated on the metal substrate.

10           In order to overcome the problem of premature curing, investigators have attempted to extrude thermoplastic coating compositions onto a metal substrate. These investigators also encountered serious problems, such as composition components having either too high of a molecular weight for easy, economical extrusion, or too low of a molecular weight thereby providing an extruded film that is too soft for many practical applications, such as on the interior or exterior of a food or beverage container. Therefore, many patents and publications in the field are directed to extrusion apparatus and extrusion methods that permit the application of such solid coating compositions to a metal substrate.

25           Investigators, therefore, have sought a solid, extrudable coating composition for use on the exterior and interior of food and beverage containers that exhibits the advantageous properties of adhesion, flexibility, chemical resistance, and corrosion inhibition, and that is economical and does not adversely affect the taste or other esthetic properties of sensitive foods and beverages



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packaged in the container. Investigators especially have sought useful extrusion coating compositions in order to reduce the environmental and toxicological concerns associated with organic solvents. In particular, investigators have sought a solid, extrusion coating composition for food and beverage containers (1) that meets increasingly strict environmental regulations, (2) has corrosion inhibition properties at least equal to existing organic solvent-based coating compositions, and (3) is easily extruded onto a metal substrate as a thin, uniform film. Such an extrusion coating composition would satisfy a long felt need in the art.

A present extrusion coating composition comprises: (a) a first polyester, (b) a second polyester, and optionally, (c) a modifying resin, wherein the Tg of the first polyester differs from the Tg of the second polyester by about 5C° to about 60C°. A present extrusion coating composition is a thermoplastic composition and is extrudable onto a metal substrate. Therefore, a crosslinking step after extrusion of the composition onto the metal substrate, or use of a crosslinking agent, is not required. A present extrusion coating composition is free of organic solvents, yet an extruded film demonstrates excellent coating properties, such as adhesion, hardness, and flexibility.

A solid, extrusion coating composition of the present invention contains no organic solvents, and, therefore, overcomes the environmental and toxicological problems associated with liquid coating compositions. The present thermoplastic extru-

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sion coating compositions also provide a sufficiently flexible extruded coating such that the coated metal substrate can be deformed without destroying film continuity. In contrast, thermosetting compositions often provide a rigid cured film thereby making it difficult to impossible to coat the metal substrate prior to deforming, i.e., shaping, the metal substrate into a metal article, like a metal closure, can, or can end. Coating a metal substrate prior to shaping the metal substrate is the present standard industrial practice.

As an added advantage, it is envisioned that a present extrusion coating composition can be used on can ends, can bodies, and closures, thereby obviating the use of different coating compositions by container manufacturers. Furthermore, a present extrusion coating composition exhibits sufficient clarity, hardness, and mar resistance after application for use as a coating on the exterior of a metal container. Accordingly, an extrusion coating composition of the present invention has a more universal range of applications, such as for the interior coating of a metal container for food or beverage products, or for the exterior coating of a metal container or a material of construction, such as aluminum siding; overcomes the environmental and toxicological concerns associated with a liquid coating composition; and overcomes disadvantages presented by other methods of applying a solid coating composition to a metal substrate.

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SUMMARY OF THE INVENTION

The present invention is directed to extrusion coating compositions that, after application to the metal substrate, effectively inhibit corrosion of the metal substrate, do not adversely affect products packaged in a container having an interior surface coated with the composition, and exhibit excellent flexibility, barrier properties, weathering, chemical resistance, and adhesion. An extrusion coating composition of the present invention can be used on closures, can ends, and can bodies, and on container interiors and exteriors, as well as materials of construction, like aluminum siding and gutters. An extrusion coating composition effectively inhibits corrosion of ferrous and nonferrous metal substrates when the composition is extruded to a surface of the metal substrate.

A present extrusion coating composition comprises: (a) a first thermoplastic polyester, having a weight average molecular weight ( $M_w$ ) of about 10,000 to about 80,000 and a  $T_g$  of greater than 45°C to about 100°C, (b) a second thermoplastic polyester having an  $M_w$  of about 10,000 to about 70,000 and a  $T_g$  of about -10°C to about 45°C, and optionally, (c) a modifying resin, such as an epoxy or phenoxy resin having an epoxy equivalent weight (EEW) of about 500 to about 15,000, wherein the  $T_g$  of the first and second polyesters differ by about 5°C to about 60°C. The composition is free of organic solvents.

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In particular, the present extrusion coating composition comprises: (a) about 10% to about 90%, by total weight of the composition, of a first polyester having an  $M_w$  of about 10,000 to about 80,000, and preferably about 15,000 to about 60,000, (b) about 10% to about 90% by total weight of the composition, of the second polyester having an  $M_w$  of about 10,000 to about 70,000, and preferably about 15,000 to about 50,000, and optionally, (c) 0% to about 25%, by total weight of the composition, of a modifying resin, for example, an epoxy or phenoxy resin having an EEW of about 500 to about 15,000, and preferably about 1000 to about 10,000, or an acrylic resin having an  $M_w$  of about 15,000 to about 100,000, or a polyolefin having an  $M_w$  of about 15,000 to about 1,000,000, or a mixture thereof, wherein the  $T_g$  of the first polyester is about 5C° to about 60C°, and preferably about 15C° to about 35C°, greater than the  $T_g$  of the second polyester. To achieve the full advantage of the present invention, the first and second polyesters have a  $T_g$  that differ by about 20C° to about 30C°. A present extrusion coating composition optionally can include: (c) 0% to about 50%, by total weight of the composition, of an inorganic filler, and (e) 0% to about 4%, by total weight of the composition, of a flow control agent.

The first and second polyesters included in a present extrusion coating composition are thermoplastic polyesters prepared from an acid, preferably terephthalic acid, isophthalic acid, naphthane dicarboxylic acid, or a mixture thereof, and an ali-

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phatic diol. At least one polyester preferably is a poly(ethylene terephthalate) (PET) or co-polyester containing terephthalic acid and isophthalic acid. Other preferred polyesters are poly(butylene terephthalate) (PBT), poly(ethylene naphthalene-2,6-dicarboxylate) (PEN), poly(trimethylene terephthalate) (PTT), and poly(trimethylene naphthanate) (PTN).

The polyesters have an acid value of 0 to about 150 mg (milligram) KOH (potassium hydroxide)/g (grams), a hydroxyl value of 0 to about 150 mg KOH/g, and a softening point of about 120°C to about 200°C. In addition, the polyesters have a melt viscosity of about 200 to about 3000 Pa.s (Pascal seconds), and a melt flow index (MFI) of about 800 g/10 min (minutes) at 200°C or about 5g/10 min at 280°C. In accordance with an important feature of the present invention, the Tg of the first polyester is greater than the Tg of the second polyester by about 5C° to about 60C°.

Components (a) and (b), and (c) and (d) and (e), if present, and other optional components are heated and intimately admixed to provide a homogenous extrusion coating composition. After cooling, the extrusion coating composition is comminuted into pellets having a particle diameter of about 1 to about 10 mm (millimeters), and preferably about 4 to about 8 mm.

As used here and hereinafter, the term "extrusion coating composition" is defined as a solid coating composition including a first and second polyesters, an optional modifying resin, an

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optional filler, an optional flow control agent, and any other optional ingredients. The term "extruded coating composition" is defined as an adherent polymeric coating resulting from extruding an extrusion  
5 coating composition onto a metal substrate.

Therefore, one important aspect of the present invention is to provide an extrusion coating composition that effectively inhibits the corrosion of ferrous and nonferrous metal substrates. An  
10 extrusion coating composition, after extrusion onto a metal substrate, provides an adherent barrier layer of an extruded coating composition that effectively inhibits corrosion, exhibits excellent flexibility and adhesion on the metal substrate, and does  
15 not adversely affect a product, such as a food or beverage, that contacts the extruded coating composition. Because of these advantageous properties, an extruded coating composition can be used to coat the interior of food and beverage containers and  
20 overcome the disadvantages associated with conventional liquid compositions and with solid compositions applied by methods such as powder coating and lamination. An extruded coating composition comprises the first and second polyesters, and, if  
25 present, the modifying resin, the filler, and the flow control agent, essentially in the amounts these ingredients are present in the extrusion coating composition.

In accordance with another important aspect of the present invention, an extruded coating composition demonstrates excellent flexibility and  
30 adhesion to a metal substrate. The excellent adhe-

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sion of an extruded coating composition to a metal substrate improves the barrier and corrosion-inhibiting properties of the coating composition. The excellent flexibility of an extruded coating composition facilitates processing of the coated metal substrate into a coated metal article, like in molding or stamping process steps, such that the cured coating composition remains in continuous and intimate contact with the metal substrate. An extruded coating composition exhibits excellent chemical resistance and does not adversely affect a food or beverage packaged in a container having an interior surface coated with the cured coating composition. An extruded coating composition is sufficiently hard to resist scratching.

In accordance with another important aspect of the present invention, an extrusion coating composition of the present invention can be extruded onto a metal substrate to provide a uniform film of extruded coating composition having a film thickness of about 1 to about 40 microns, and preferably 2 to about 30 microns. Uniform films of such a small thickness have not been attainable using powder coating composition and methods. In addition, a present extrusion coating composition can be used both on the interior and exterior of can bodies and can ends, thereby obviating the need for a container manufacturer to use multiple coating compositions.

These and other aspects and advantages of the present invention will become apparent from the following detailed description of the preferred embodiments.

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DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

An extrusion coating composition of the present invention, after application to a metal substrate, provides an extruded coating composition that effectively inhibits the corrosion of metal substrates, such as, but not limited to, aluminum, iron, steel and copper. An extruded coating composition also demonstrates excellent adhesion to the metal substrate, excellent chemical resistance and scratch resistance, and excellent flexibility. An extruded coating composition does not impart a taste to foods or beverages that contact the extruded coating composition.

In general, a present extrusion coating composition comprises: (a) a first polyester having an  $M_w$  of about 10,000 to about 80,000, and a  $T_g$  of greater than 45°C to about 100°C, and (b) a second polyester having an  $M_w$  of about 10,000 to about 70,000, and a  $T_g$  of about -5°C to about 45°C. The first polyester has  $T_g$  that is about 5°C to about 60°C greater than the  $T_g$  of the second polyester. The extrusion coating composition is a solid and is free of organic solvents.

An extrusion coating composition optionally can further include: (b) a modifying resin, such as an epoxy or phenoxy resin having an EEW of about 500 to about 15,000 and/or (c) a filler and/or (d) a flow control agent. In addition, a present extrusion coating composition can include optional ingredients that improve the esthetics of the composition, that facilitate manufacture and/or



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extrusion of the composition, or that improve a functional property of the composition. The individual composition ingredients are described in more detail below.

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(a) Polyesters

In accordance with an important feature of the present invention, an extrusion coating composition includes a first thermoplastic polyester and a second thermoplastic polyester in a total amount of about 50% to about 100%, by total weight of the composition. Preferably, an extrusion composition includes about 55% to about 90%, by total weight of the composition, of the first and second polyesters. To achieve the full advantage of the present invention, an extrusion coating composition includes about 60% to about 85% of the first and second polyesters, by total weight of the composition.

The first and second polyesters are present in the extrusion coating composition in a weight ratio of first polyester to second polyester of about 9 to 1 to about 1 to 9, preferably from about 6 to 1 and about 1 to 6. To achieve the full advantage of the present invention, the weight ratio of first polyester to second polyester is about 3 to 1 to about 1 to 3.

It should be understood that the first polyester can be a single polyester or a mixture of polyesters, as long as each polyester comprising the first polyester has a Tg of about 45°C to about 100°C. Similarly, the second polyester can be a

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single polyester or a mixture of polyesters, as long as each polyester comprising the second polyester has a Tg of about -10°C to about 40°C. Therefore, as used here and hereafter, the term "first polyester" or "second polyester" refers to a single polyester or to a mixture of two or more polyesters.

Both the first and second polyesters are prepared from a dicarboxylic acid, preferably an aromatic dicarboxylic acid, and an aliphatic diol. These ingredients are interacted to provide a polyester having an  $M_w$  of about 10,000 to about 80,000, preferably of about 15,000 to about 60,000, and to achieve the full advantage of the present invention, about 20,000 to about 50,000. Accordingly, the polyesters are considered high molecular weight polyesters. The polyesters have an acid number of about 0 to about 150 mg KOH/g, and preferably about 5 to about 100 mg KOH/g. The polyesters have a hydroxyl number of 0 to about 150 mg KOH/g, and preferably about 5 to about 100 mg KOH/g.

Useful polyesters also possess properties that allow the polyesters to be blended with the optional modifying resins and other composition components, to be extruded onto a metal substrate, and to provide an extruded coating composition having the necessary adhesion and flexibility to be applied to a metal substrate prior to shaping the metal substrate into a metal article. The polyesters also are sufficiently nonreactive such that, when the extrusion composition is melted prior to and during extrusion, the polyesters do not enter a

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crosslinking reaction with the optional modifying resin or other composition components.

A polyester used in a present extrusion coating composition provides an extruded coating composition having good film tensile strength, good permeation resistance, retortability, and good barrier properties. The polyesters, and the extrusion coating composition, therefore, have a softening point of 140°C or greater, as measured using the procedure set forth in DIN 52011. Preferably, the polyesters and extrusion coating composition have a softening point of 120°C to about 200°C. Within this temperature range, the extruded coating compositions exhibited improved pasteurization/retortability resistance.

The first polyester has a Tg of greater than 45°C to about 100°C, and preferably about 50°C to about 80°C. To achieve the full advantage of the present invention, the first polyester has a Tg of about 55°C to about 75°C.

The second polyester has a Tg of about -10°C to about 45°C, preferably 0°C to about 35°C. To achieve the full advantage of the present invention, the second polyester has a Tg of about 5°C to about 25°C.

The first and second polyesters have Tg's that differ by about 5°C to 60°C, and preferably about 15°C to 35°C. To achieve the full advantage of the present invention, the difference in Tg's, or  $\Delta T_g$ , between the first and second polyesters is about 20°C to about 30°C. In this  $\Delta T_g$  range, the blend of first and second polyesters is sufficiently

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flexible to permit deformation of an extruded coating composition without forming cracks, and is sufficiently hard to exhibit excellent chemical and mar resistance. If the  $\Delta T_g$  of the first and second  
5 polyesters is less than about  $50^\circ\text{C}$ , the advantages of a blend of polyesters is not fully realized.

The  $T_g$  of the first and second polyester is measured by the following procedure. The  $\Delta T_g$  is simply the difference between the  $T_g$  of the first  
10 polyester and the  $T_g$  of the second polyester.

The glass transition temperature ( $T_g$ ) of a polymer is the temperature at which an amorphous material changes from a brittle vitreous state to a plastic state. The  $T_g$  of a polyester was determined  
15 using a Differential Scanning Calorimetry (DSC) instrument in a standard mode. In particular, the method utilized a TA Instruments Model 2920 DSC instrument, with a helium flow gas of  $35\text{ cm}^3/\text{minute}$ . Data was collected on a TA Instruments 3100 Thermal  
20 Analyst Computer using an indium standard for temperature calibration.

An indium standard first was prepared in accordance with ISO9000 calibration documentation. A small piece of indium was cut from the stock stan-  
25 dard, and placed into an aluminum DSC sample pan with cover, then crimped closed. The standard was heated from  $100^\circ\text{C}$  to  $180^\circ\text{C}$  at  $20^\circ\text{C}$  per minute. A helium gas purge at  $35\text{ cc}$  per minute was used. The melting point and heat of melt calculations were  
30 made of the indium standard, and the results were entered into the calibration file stored in the Thermal Analyst program on the TA 3100 computer.

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A sealed DSC pan containing a polyester sample was placed into the DSC instrument at room temperature. The DSC heating chamber cover was closed. The sample was cooled to  $-40^{\circ}\text{C}$  using either  
5 liquid nitrogen in the cooling can or the RSC cooling system. After equilibration of the DSC was reached, the sample was heated at  $20^{\circ}\text{C}$  per minute through the  $T_g$  of the sample by about  $10^{\circ}\text{C}$  and then cooled to  $-40^{\circ}\text{C}$  again. The sample was reheated at  
10  $20^{\circ}\text{C}$  per minute through the glass transition temperature and the  $T_g$  was determined. The glass transition temperature was calculated at the temperature at the mid-point in the change in heat capacity.

Useful first and second polyesters also  
15 exhibit a melt viscosity of about 200 to about 3000 Pa.s (Pascal seconds). The melt viscosity is measured using a cone/plate viscometer by the standard PIN I50 1133 procedure. The melt flow index (MFI), as measured using DIN 53735, of a useful polyester  
20 is about 800 g/10 min. at  $200^{\circ}\text{C}$  or about 5 g/10 min. at  $280^{\circ}\text{C}$ .

The first and second polyesters typically are prepared by condensing a dicarboxylic acid with an aliphatic diol. To provide polyesters having  
25 optimum properties for an extrusion coating composition for a food or beverage container, the dicarboxylic acid preferably is an aromatic dicarboxylic acid. To achieve the full advantage of the present invention, the dicarboxylic acid comprises tere-  
30 phthalic acid, isophthalic acid, a naphthalene dicarboxylic acid, and mixtures thereof. It is also understood that an esterifiable derivative of a di-

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carboxylic acid, such as a dimethyl ester or anhydride of a dicarboxylic acid, can be used to prepare the polyester.

In particular, exemplary dicarboxylic acids used to prepare the first and second polyesters include aliphatic and aromatic dicarboxylic acids, such as, but not limited to, phthalic acid, isophthalic acid, terephthalic acid, adipic acid, malonic acid, 2,6-naphthalenedicarboxylic acid, 1,5-naphthalenedicarboxylic acid, hexahydroterephthalic acid, 1,4-cyclohexanedicarboxylic acid, sebacic acid, azeleic acid, succinic acid, glutaric acid, fumaric acid, adipic acid, and mixtures and esterifiable derivatives thereof. Substituted aliphatic and aromatic dicarboxylic acids, such as halogen or alkyl-substituted dicarboxylic acids, also are useful. Preferably, at least 60 mol % aromatic dicarboxylic acids are used to prepare the polyester.

Exemplary, but nonlimiting, diols used to prepare the first and second polyesters include ethylene glycol, diethylene glycol, triethylene glycol, propylene glycol, dipropylene glycol, hexylene glycol, butylene glycol, pentylene glycol, neopentyl glycol, trimethylpropane diol, 1,4-cyclohexanedimethanol, 1,10-decanediol, 2,2-dimethyl-1,3-propanediol, 2,2,4,4-tetramethyl-1,3-cyclobutendiol, a polyethylene or polypropylene glycol having a molecular weight of about 500 or less, and mixtures thereof. A small amount of a triol or polyol, i.e., 0 to 3 mole % of diol, can be

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used to provide a partially branched, as opposed to linear, polyester.

The diol and the dicarboxylic acid, in correct proportions, are interacted under standard esterification procedures to provide a first and second polyester having the necessary  $M_w$ , Tg, molecular weight distribution, branching, crystallinity, and functionality for use in a present extrusion coating composition. Examples of useful polyesters can be prepared as set forth in Brünig et al. U.S. Patent No. 4,012,363, incorporated here by reference, and in Canadian Patent No. 2,091,875.

In addition, useful polyesters are commercially available under the tradename DYNAPOL, from Hüls AG, Berlin, Germany. Examples of specific polyesters are DYNAPOL P1500, DYNAPOL P1510, and DYNAPOL P1550, each available from Hüls AG and based on terephthalic acid and/or isophthalic acid. Another useful class of polyesters is the GRILESTA polyesters, like GRILESTA V 79/20, available from EMS. Other useful commercial polyesters include, but are not limited to, SHELL CARIPAK P76, available from Shell Chemicals (Europe), Switzerland; SELAR polyesters, like SELAR PT 6129 and SELAR PT 8307, both available from DuPont Packaging and Industrial Polymers, Wilmington, DE. The CRAFTIN polyesters, like CRAFTIN 6129, available from DuPont, also can be used. CELANEX 3100 and HOECHST 1700A also are useful polyesters.

A polyester also can be prepared by condensing a dicarboxylic acid or derivative of a dicarboxylic acid described above with a low molecu-

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lar weight epoxy compound. The low molecular weight epoxy compound contains an average of about 1.5 to about 2.5 epoxy groups per molecule and has an EEW of about 150 to about 500. An exemplary low molecular weight epoxy compound is EPON 828, available from Shell Chemical Co., Houston, TX.

Especially useful polyesters include polyethylene terephthalates (PET), polybutylene terephthalates (PET), polyethylene naphthanates (PEN), and polybutylene naphthalates (PBN), polytrimethylene terephthalate (PTT), polytrimethylene naphthate (PTN), and mixtures thereof.

(b) Optional Modifying Resin

The extrusion coating composition also includes 0% to about 25%, by total weight of the composition, of an optional modifying resin. Preferably, an extrusion composition contains about 2% to about 20% of an optional modifying resin, by total weight of the composition. To achieve the full advantage of the present invention, the extrusion composition contains about 8% to about 15% of an optional modifying resin, by total weight of the composition.

The optional modifying resin does not substantially react with the polyester during manufacture of the extrusion coating composition or during the extrusion process. Accordingly, after application to a metal substrate, the extrusion coating composition is not subjected a curing step. The modifying resin, however, improves the barrier



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properties of the extruded coating and the adhesion of the extruded coating composition to the metal substrate.

One useful modifying resin is an epoxy or  
5 phenoxy resin having an EEW of about 500 to about 15,000, and preferably about 1000 to about 10,000. To achieve the full advantage of the present invention, the epoxy or phenoxy resin has an EEW of about 2000 to about 8000. Within the above EEW range for  
10 the epoxy or phenoxy resin, the extruded coating composition is sufficiently flexible to permit deformation of an extruded coating composition without forming cracks, and is sufficiently hard to exhibit excellent chemical and mar resistance.

15 Preferably, the epoxy or phenoxy resin is a solid material that can be melted and admixed with a molten polyester to provide an extrusion coating composition of the present invention. Preferred epoxy and phenoxy resins contain an average of about  
20 1.5 to about 2.5 epoxy groups per molecule of epoxy resin, but epoxy novolac resins containing greater than about 2.5 epoxy groups per molecule also can be used, i.e., containing about 2.5 epoxy groups to about 6 epoxy groups.

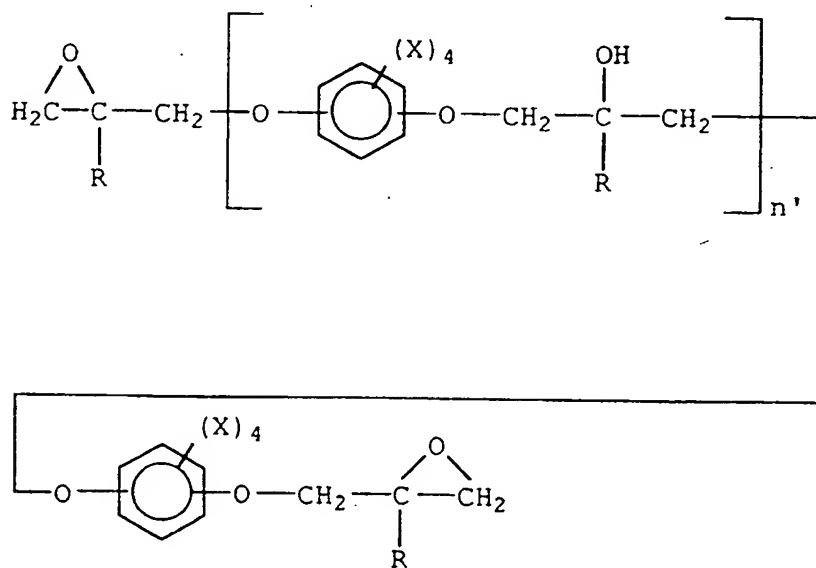
25 The epoxy or phenoxy resin can be an aliphatic resin or an aromatic resin. The preferred epoxy and phenoxy resins are aromatic, like epoxy and phenoxy resins based on the diglycidyl ether of bisphenol A or bisphenol F. An epoxy resin can be  
30 used in its commercially available form, or can be prepared by advancing a low molecular weight epoxy

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compound by standard methods well known to those skilled in the art.

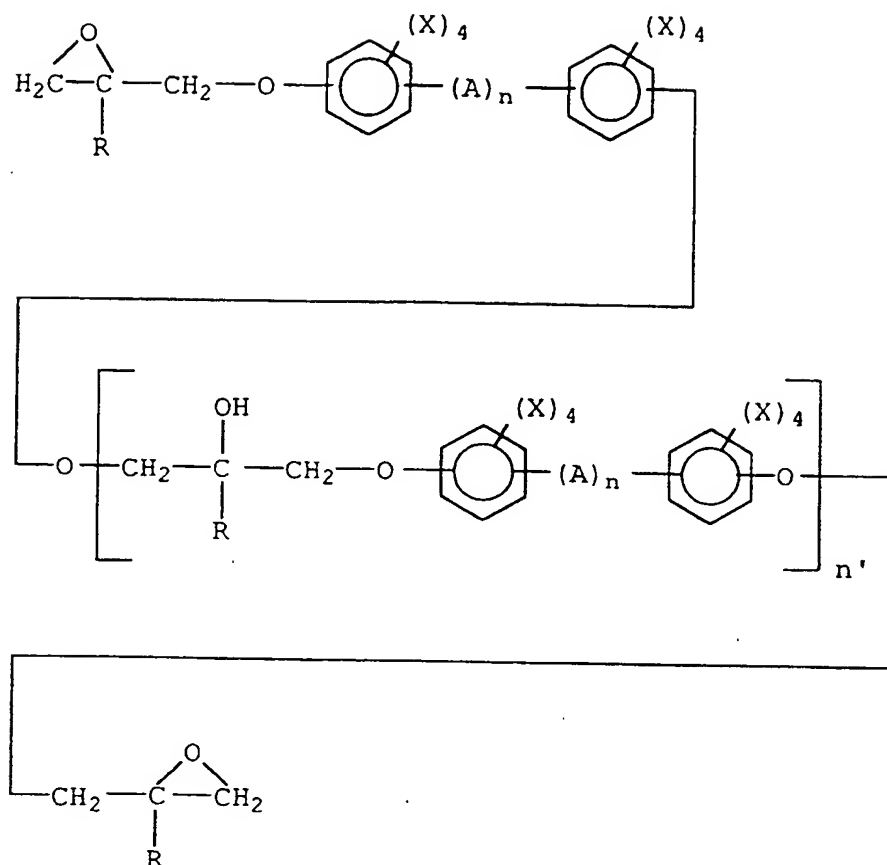
Exemplary epoxy resins include, but are not limited to, EPON 1004, EPON 1007, and EPON 1009, all available from Shell Chemical Co., Houston, Texas, or ARALDITE® 6099, available from CIBA-GEIGY Corp., Ardsley, NY.

In general, suitable epoxy and phenoxy resins are aliphatic-, cycloaliphatic-, or aromatic-based epoxy resins, such as, for example, epoxy resins represented by structural formulae I and II:



(I)

- 25 -



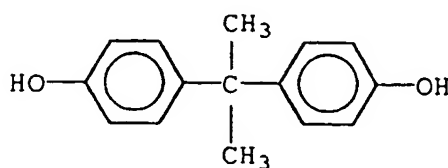
(II)

wherein each A is, independently, a divalent hydrocarbyl group having 1 to about 12, preferably 1 to about 6, and most preferably 1 to about 4, carbon atoms; each R is, independently, hydrogen or an alkyl group having 1 to about 3 carbon atoms; each X is, independently, hydrogen, a hydrocarbyl or hydrocarbyloxy group having 1 to about 12, preferably 1 to about 6, and most preferably 1 to about 4, carbon atoms, or a halogen atom, preferably chlorine or

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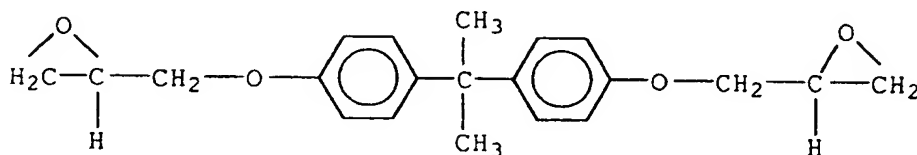
bromine; n is 0 or 1, and n' has an average value of about 2 to about 30, and preferably 10 to about 30.

In particular, the preferred epoxy and phenoxy resins are the (diglycidyl ether/bisphenol-A) resins, i.e., polyether diepoxides prepared by  
 5 the polymeric adduction of bisphenol-A (III)



(III)

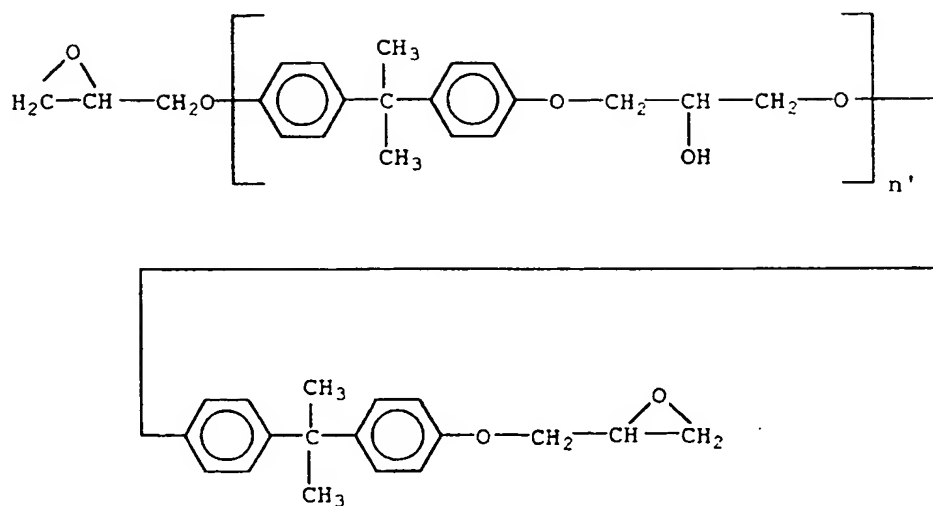
and the diglycidyl ether of bisphenol-A (IV).



(IV)

- 10 In this case, the epoxy resin is a mixture including polymeric species corresponding to different values of n' in the following idealized formula V:

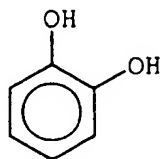
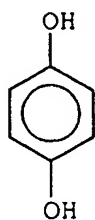
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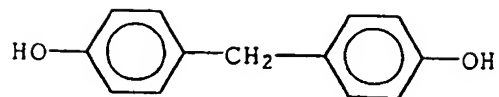
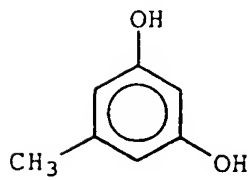
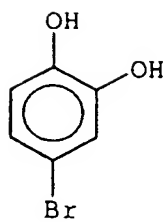
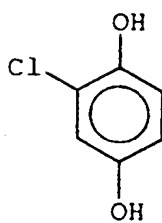
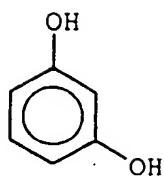
(V)

wherein  $n'$  is a number from about 2 to about 30.

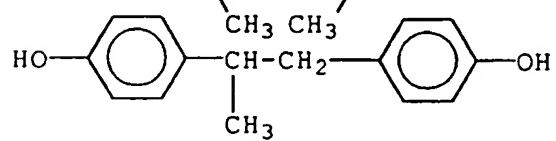
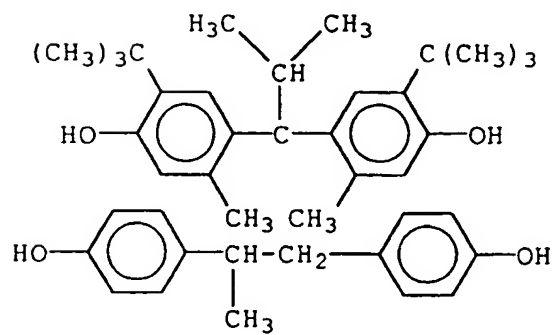
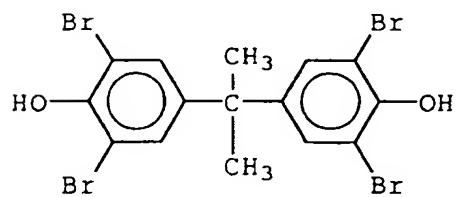
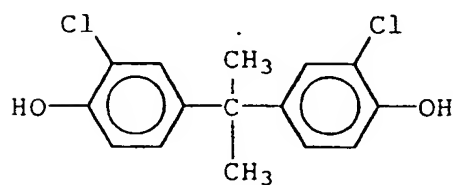
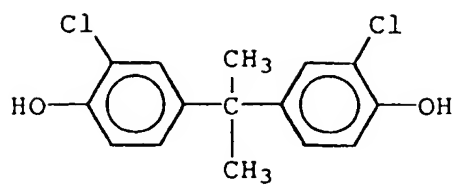
In addition to bisphenol-A, useful epoxy  
and phenoxy resins can be prepared by advancing a  
diglycidyl ether of a bisphenol listed below with an  
5 exemplary, but nonlimiting, bisphenol listed below:



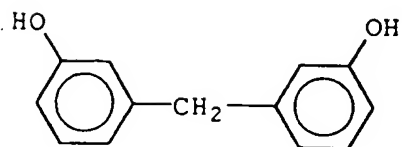
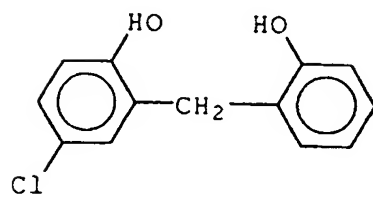
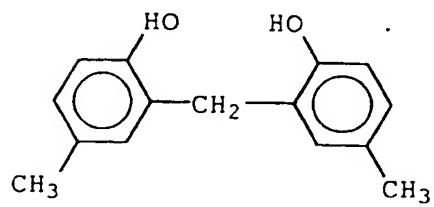
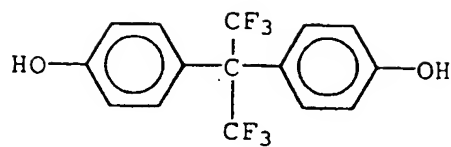
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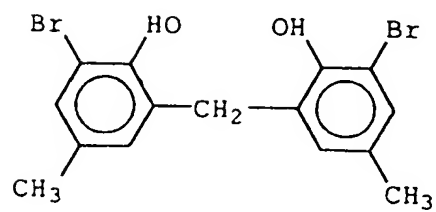
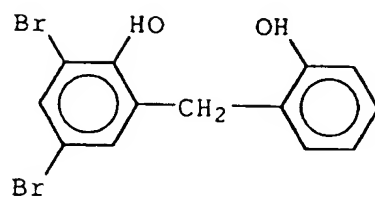
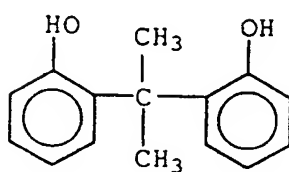
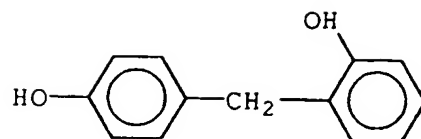


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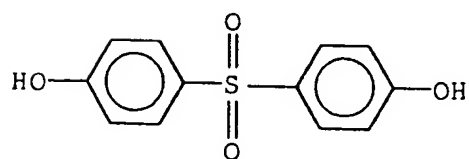
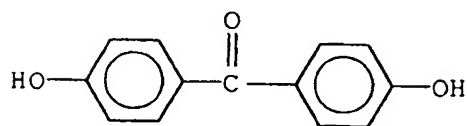
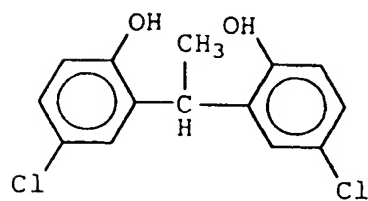
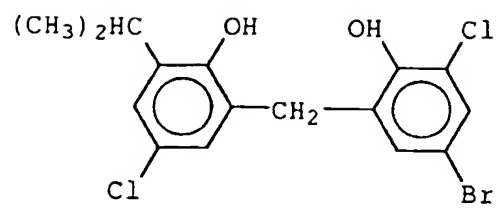




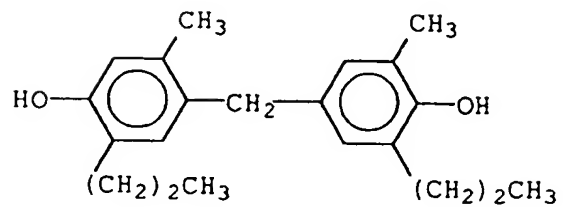
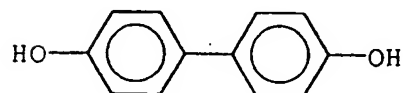
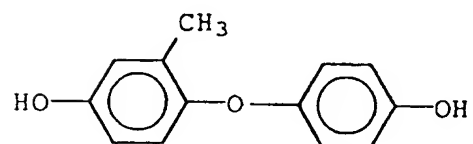
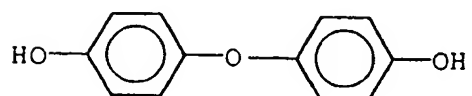
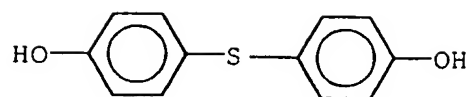
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Presently, governmental agencies are issuing regulations directed to the amount of free epoxy groups in coatings present on food and beverage containers and closures. Therefore, for some applications, an epoxy resin is not a suitable modifying resin. In these applications, an acrylic resin or a polyolefin resin can be used as the optional modifying resin. A mixture of an epoxy resin, an acrylic resin, and a polyolefin resin also can be used.

The acrylic resin has an  $M_w$  of about 15,000 to about 100,000, and preferably about 20,000 to about 80,000. Acrylic resins include, but are not limited to, homopolymer and copolymers of acrylic acid, methacrylic acid, esters of acrylic acid, esters of methacrylic acid, acrylamides, and methacrylamides.

The polyolefin resin has an  $M_w$  of about 15,000 to about 1,000,000, and preferably about 25,000 to about 750,000. Polyolefin resins include, but are not limited to, homopolymers and copolymers of ethylene, propylene, ethylene-propylene blends, 1-butene, and 1-pentene. The polyolefin also can contain functionalized olefins, such as an olefin functionalized with hydroxy or carboxy groups.

### (c) Optional Inorganic Filler

To achieve the full advantage of the present invention, an extrusion coating composition includes 0% to about 50%, preferably 0% to about 30%, and most preferably 0% to about 25%, by total

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weight of the composition, of an inorganic filler. An inorganic filler is included to improve the physical properties of an extruded coating composition.

Exemplary inorganic fillers used in the coating composition of the present invention include, but are not limited to, clay, mica, aluminum silicate, fumed silica, magnesium oxide, zinc oxide, barium oxide, calcium sulfate, calcium oxide, aluminum oxide, magnesium aluminum oxide, zinc aluminum oxide, magnesium titanium oxide, iron titanium oxide, calcium titanium oxide, and mixtures thereof. The inorganic filler is essentially nonreactive and is incorporated into the extrusion coating composition in the form of a powder, generally about 10 to 200 microns in diameter, and in particular, about 50 microns to about 125 microns in diameter.

(d) Optional Flow Control Agent

An extrusion coating composition of the present invention also can contain a flow control agent to assist in achieving a uniform film of extruded coating composition on the metal substrate. The flow control agent is present in an amount of 0% to about 6%, and preferably 0% to about 5%, by total weight of the composition.

An exemplary, but nonlimiting, flow control agent is a polyacrylate available from Henkel Corporation, as PERENOL F 30 P. Another useful polyacrylate flow control agent is ACRYLON MFP. Numerous other compounds and other acrylic resins

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known to persons skilled in the art also can be used as a flow control agent.

(e) Other Optional Ingredients

An extrusion coating composition of the present invention also can include other optional ingredients that do not adversely affect the extrusion coating composition or an extruded coating composition resulting therefrom. Such optional ingredients are known in the art, and are included in an extrusion coating composition to enhance composition esthetics, to facilitate manufacturing and application of the extrusion coating composition, and to further improve a particular functional property of an extrusion coating composition or an extruded coating composition resulting therefrom.

Such optional ingredients include, for example, dyes, pigments, anticorrosion agents, antioxidants, adhesion promoters, light stabilizers, and mixtures thereof. Each optional ingredient is included in a sufficient amount to serve its intended purpose, but not in such an amount to adversely affect an extrusion coating composition or an extruded coating composition resulting therefrom.

For example, a pigment, in an amount of 0% to about 50% by weight of the composition, is a common optional ingredient. A typical pigment is titanium dioxide, barium sulfate, carbon black, or an iron oxide. In addition, an organic dye or pigment can be incorporated in the extrusion coating composition.

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In addition, an additional polymer, i.e., a second modifying polymer, can be added to the extrusion coating composition to improve the properties of the extruded coating composition. The second modifying polymer preferably is compatible with the other composition components and does not adversely affect the extruded coating composition. To achieve a coated metal substrate having a nongloss finish, the second modifying polymer can be substantially incompatible with the polyester and optional modifying polymer. The second modifying polymer can be a thermoplastic or a thermoset polymer, and is present in the extrusion coating composition in an amount of 0% to about 50%, and preferably 0% to about 20%, by total weight of the composition.

Nonlimiting examples of optional second modifying polymers that can be incorporated into the extrusion coating composition are a carboxylated polyester, a carboxylated polyolefin, a polyamide, a fluorocarbon resin, a polycarbonate, a styrene resin, an ABS (acrylonitrile-butadiene-styrene) resin, a chlorinated polyether, a urethane resin, and similar resins. Polyamide resins include nylon 66, nylon 6, nylon 610, and nylon 11, for example. A useful polyolefin is polyethylene or polypropylene, including homopolymers and copolymers, for example. Fluorocarbon resins include tetrafluorinated polyethylene, trifluorinated monochlorinated polyethylene, hexafluorinated ethylene-propylene resin, polyvinyl fluoride, and polyvinylidene fluoride, for example. However, even if an optional second modifying polymer is added to the extrusion

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coating, the extrusion coating composition is free of a crosslinking agent and is not subjected to a curing step after extrusion onto a metal substrate.

5 An extrusion coating composition of the present invention can be prepared by methods well known in the art, such as by individually heating the first polyester, the second polyester, and the optional modifying resin to a sufficient temperature to melt each ingredient, then admixing the molten  
10 polyesters and optional modifying resin, such as in a single screw or double screw extruder, to provide a uniform extrusion coating composition. Optional ingredients can be added to the extrusion coating composition either by incorporation into one of the  
15 molten ingredients prior to admixture of the molten ingredients, or can be added to the molten extrusion coating composition after ingredients have been admixed. If an optional second modifying polymer is present in the composition, the second modifying  
20 polymer is melted and added to the molten extrusion coating composition at any convenient step of the manufacturing process. Alternatively, all composition ingredients can be admixed in the solid state, followed by melting the resulting admixture and  
25 extrusion, to provide a uniform molten composition.

After a uniform molten composition is prepared, the extrusion coating composition is allowed to cool and solidify. The resulting extrusion coating composition then is formed into pellets  
30 having a particle diameter of about 1 to about 10 mm. The pellets are stored and kept dry until use in an extrusion process. Preferably, the pellets



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are subjected to a heating step prior to extrusion in order to expel any water absorbed by the extrusion coating composition during storage.

To demonstrate the usefulness of an extrusion coating composition of the present invention, the following examples were prepared, then extruded onto a metal substrate to provide a coated metal substrate. The coated metal substrates then were tested for use as a food or beverage container. The extruded coatings were tested for an ability to inhibit corrosion of a metal substrate, for adhesion to the metal substrate, for chemical resistance, for flexibility, and for scratch and mar resistance. Examples 1 through 31 illustrate some important features and embodiments of an extrusion coating composition of the present invention, and illustrate methods of extruding a coating composition of the present invention. Examples A and B are comparative examples containing a single polyester resin.

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Comparative Examples A and B		
Ingredient	A (wt. %)	B (wt. %)
DYNAPOL P 1500 <sup>1)</sup>	90.55	99.45
ARALDITE <sup>®</sup> GT 6099 <sup>2)</sup>	8.90	0
5 ACRYLON MFP <sup>3)</sup>	0.55	0.55

<sup>1</sup> A polyester available from Hüls AG, having softening point of 170-176°C, a Tg of about 23°C, and a melt viscosity of about 70-80 Pa.s at 240°C;

10 <sup>2</sup> An epoxy resin available from CIBA-GEIGY having an EEW of about 2500 to about 4000; and

<sup>3</sup> An acrylic flow central agent.

The extrusion coating compositions of Comparative Examples A and B were prepared by melting the polyester and adding the flow control agent, with stirring, to the molten polyester. The resulting mixture was heated to maintain the polyester in the molten state. Then, the previously melted epoxy resin was admixed with the molten polyester by passing the epoxy resin and polyester through a twin blade extruder. The resulting compositions of Comparative Examples A and B were allowed to cool to room temperature and solidify. The solid compositions then were formed into pellets, the majority having a particle diameter of about 1 to about 10 mm. The extrusion coating compositions of Comparative Examples A and B had a melt flow index (MFI) of 62.2 g/10 minutes at 200°C, and a melting peak of 172.2°C (determined by differential scanning calorimetry (DSC)).

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The compositions of Examples 1-31 were prepared in an essentially identical manner to the comparative compositions of Examples A and B, except a second polyester resin is included in a majority of Examples 1-31. Examples 2, 8, and 16 contain a single polyester, and are comparative examples. Examples 30 and 31 contain a single polyester, and are comparative examples. Examples 30 and 31 contain additional composition ingredients, for example, a pigment, and are prepared in an essentially identical manner as Comparative Examples A and B.

Ingredient	Ex. 1 <sup>4)</sup>	Ex. 2 (comparative)	Ex. 3	Ex. 4	Ex. 5	Ex. 6
CRASTIN 6129 <sup>5)</sup>	47.25	100.00	89.75	74.75	49.75	24.75
DYNAPOL 1500 <sup>1)</sup>	47.25		9.75	24.75	49.75	74.75
ARALDITE <sup>®</sup> GT6099 <sup>2)</sup>	5.00					
ACRYLON MFP <sup>3)</sup>	0.50		0.50	0.50	0.50	0.50

<sup>4)</sup> Percent by weight in the composition; and

<sup>5)</sup> A polybutylene terephthalate polyester, available from DuPont Packaging and Industrial Polymers, Wilmington, DE, having a melting point of 225°C, a Tg of about 50°C, and a melt flow index of about 6 to 8 g/10 min. at 240°C.

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	Ingredient	Ex. 7 <sup>6)</sup>	Ex. 8 (comparative)	Ex. 9	Ex. 10	Ex. 11	Ex. 12
	CARIPAK P76 <sup>6)</sup>	47.25	100.00	89.75	74.75	49.75	24.75
	DYNAPOL 1500 <sup>1)</sup>	47.25		9.75	24.75	49.75	74.75
5	ARALDITE <sup>®</sup> GT6099 <sup>2)</sup>	5.00					
	ACRYLON MFP <sup>3)</sup>	0.50		0.50	0.50	0.50	0.50

10 <sup>6)</sup> A polyethylene terephthalate polyester, available from Shell  
Chemicals (Europe), Switzerland, having a melting point of  
250°C and a Tg of about 70°C.

Ingredient	Ex. 13 <sup>1)</sup>	Ex. 14	Ex. 15	Ex. 16 (Comparative)	Ex. 17	Ex. 18	Ex. 19	Ex. 20
SELAR PT8307 <sup>1)</sup>	70.87	47.25	23.62	100.00	89.75	74.75	49.75	24.75
DYNAPOL 1500 <sup>1)</sup>	23.62	47.25	40.87		9.75	24.75	49.75	74.75
ARALDITE <sup>®</sup> GT6099 <sup>2)</sup>	5.01	5.00	5.01					
ACRYLON MFP <sup>3)</sup>	0.50	0.50	0.50		0.50	0.50	0.50	0.50

<sup>7)</sup> A modified polyester available from DuPont Packaging and Industrial Polymers, Wilmington, DE, having a melting point of 220°C, a Tg of about 70°C, and a melt viscosity of about 560 Pa.s at 280°C.

[illegible]

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The following Examples 30 and 31 are pigmented embodiments of the extrusion coating compositions.

5	Ingredient	Ex. 30 <sup>4)</sup>	Ex. 31
	SELAR PT8307	20.00	36.25
	Titanium Dioxide <sup>8)</sup>	12.00	20.00
	DYNAPOL 1500 <sup>1)</sup>	58.55	
	CRASTIN 6129 <sup>5)</sup>		36.25
	Wax <sup>9)</sup>		2.00
10	DYNAPOL 1510 <sup>10)</sup>		5.00
	ARALDITE GT6099 <sup>2)</sup>	8.90	
	ACRYLON MFP <sup>3)</sup>	0.55	0.50

<sup>8)</sup> Pigment;

<sup>9)</sup> Hoechst wax C; and

15 <sup>10)</sup> A polyester, available from Hüls AG, having a melting point of 147-154°C, a Tg of about 23°C, a melt viscosity of 35-40 Pa.s at 240°C, and a melt index of about 120 g/10 min at 200°C.

The first test performed on extrusion  
 20 coating compositions of the present invention was to determine whether the first and second polyesters retained their individual identities (i.e., their distinct Tg's) during the processes of manufacturing the composition and extruding the composition onto a  
 25 metal substrate, or whether a transesterification reaction occurred to form an alloy having a single Tg. In this test, eight separate samples of extrusion coating compositions were treated in an extruder at 300°C for various lengths of time. The sam-  
 30 ples contained either a blend of DYNAPOL 1500 and

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CARIPAK P76, or a blend of DYNAPOL 1500 and a polyethylene naphthalenedicarboxylate (PEN 14991 available from Eastman Chemicals, Kingsport, TN).

The extruded compositions were analyzed by  
5 Differential Scanning Calorimetry (DSC). The individual polyesters present in the extrusion coating compositions also were tested by DSC. In particular, a TA Instrument Model 2920 Differential Scanning Calorimetry instrument was used to determine if  
10 the extruded products were blends or alloys of the starting polyester. Samples were prepared for analysis by cutting a small sample (e.g., 10 to 15 mg in weight) from an extruded film with a razor blade. The sample was placed into an aluminum DSC sample  
15 pan, covered, and sealed. The sample pan then was placed into the DSC apparatus and cooled to -50°C. Each sample was heated at a rate of 20°C per minute to 300°C.

After a first heating, each sample was  
20 rapidly cooled from its melt point down to -50°C. A second heating was performed on each sample, and the thermal transitions were recorded. Each extruded composition was analyzed under the same conditions as the individual polyesters. The first heating of  
25 each extruded composition revealed multiple transitions that were matched with transitions attributed to the starting polyesters. For example, a P1500/-PEN sample conditioned at 300°C for 2 minutes provided a Tg that matched the DYNAPOL starting component and a Tg that matched the PEN starting component.  
30 No other thermal transitions were detected. The thermal analysis results showed that the ex-

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truded composition was a blend of the starting polyesters. A polymer alloy was not formed from the individual polyesters. Thermal analyses using different conditioning times all revealed similar  
5 findings. Thermal analysis of the DYNAPOL 1500/-CARIPAK P76 extrusion coating compositions after extrusion also was a blend of the starting polyesters, as opposed to an alloy.

Extrusion coating compositions of Examples  
10 1-31 and Comparative Examples A and B were extruded onto a metal substrate to provide a coated metal substrate having an adherent barrier layer of an extruded composition. Typically, the compositions are applied to a sheet or coil of a metal substrate  
15 moving relative to an extruder which applies the composition to the metal substrate. The extruder comprises a screw to transfer the molten composition, and a die to apply the composition to the metal substrate at a predetermined thickness. The  
20 extruder applies the extrusion coating composition to the metal substrate as a layer of about 1 to about 40, and preferably about 2 to about 30, microns. To achieve the full advantage of the present invention, the extruded coating composition is about  
25 1 to about 10 microns thick.

The coated metal substrates then were tested for use as the interior surface of a food or beverage container. As will be demonstrated more fully hereafter, an extruded coating composition  
30 resulting from extruding an extrusion coating composition of the present invention is suitable as the interior coating of a metal container for food



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or beverages. A present extrusion coating composition provided excellent extruded coatings in the absence of a curing step.

In particular, an extrusion coating  
5 composition of the present invention can be applied to essentially any metal substrate. Nonlimiting examples of metal substrates are aluminum, tin-free steel, tinplate, steel, zinc-plated steel, zinc  
10 alloy-plated steel, lead-plated steel, lead alloy-plated steel, aluminum-plated steel, aluminum alloy-plated steel, and stainless steel.

In the extrusion coating method, the extrusion coating composition is slowly and carefully melted by first heating the composition at  
15 about 100°C to about 120°C, then slowly increasing the temperature to about 180°C to about 240°C to completely melt the extrusion coating composition. The upper temperature is not especially limited, but is sufficiently high to melt the composition. The  
20 composition should not be heated to a temperature far above the melting point (i.e., greater than about 100C° above the melting point) in order to minimize or avoid, reactions between the first and second polyesters, between the polyesters and the  
25 optional modifying resin, or degradation of the polyesters.

An important feature of the present extrusion coating compositions is stability of the composition at the melting point temperature. Extrusion coating compositions of the present invention  
30 increase in viscosity by less than 100 Pa.s when maintained at, or above, the melting point for

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twenty minutes. This slight increase in viscosity shows that the polyesters and epoxy are not reacting, i.e., undergoing cure, at the melting point to form a crosslinked resin, and that the polyesters are not degrading. If crosslinking did occur, the viscosity would rise dramatically, and it would be difficult to impossible to extrude the extrusion coating composition onto a metal substrate. A decrease in viscosity indicates that the polyesters were degrading at the melting point.

In addition, the metal is heated prior to extrusion to a temperature of about 60°C to about 300°C, preferably about 80°C to about 260°C. Pre-heating of the metal substrate is important to achieve sufficient flow of the extrusion coating composition on the metal substrate, and to achieve adhesion of the extruded composition to the metal substrate.

The extrusion coating composition does not cure or crosslink to any substantial extent during, or after, extrusion onto the heated substrate. Therefore, a step of curing the extruded composition at an elevated temperature is omitted. However, to optimize the properties of the extruded composition, the coated metal substrate, either before or after cooling, preferentially is subjected to a post-extrusion heating step conducted at about 120°C to about 550°C (peak metal temperature) for about 5 to about 30 seconds, and preferably about 180°C to about 450°C for about 10 to about 20 seconds.

The resulting extruded coating compositions had a smooth, glossy appearance, and were

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defect free. The extruded coatings had good adhesion and exhibited good barrier and anticorrosion properties.

In particular, the present extrusion coating compositions provide a highly protective, self-lubricating layer when extruded onto a metal substrate. The compositions can be extruded onto metal coils or sheets at a high speed to provide a layer of extruded composition having a thickness of about 1 to about 40 microns, preferably about 2 to about 30 microns. For many applications, the extruded composition has a thickness of about 1 to about 10 microns. Typically, the extruder has a length-to-diameter ratio (L/D) of about 10:1 to about 40:1, and preferably about 15:1 to about 30:1. The extruder can contain a single screw, or twin screws, either conrotatory or counter rotatory. The extruded composition outperforms liquid and powder coating compositions, and reduces the cost of applying a thin protective coating on a metal substrate.

Overall, an extrusion coating composition of the present invention demonstrates the advantages of optionally eliminating chemical pretreatment of the metal substrate; optionally substituting a small induction oven for preheating the metal substrate and for postheating in place of a large convection oven for drying a liquid composition; using a solid composition containing no organic compounds in place of a liquid containing organic solvents; elimination of lubricating stations; and elimination of solvent incinerators.

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Various tests were performed on the extrusion coating compositions. These tests showed that the present extrusion coating compositions exhibit coating properties at least equal to current commercial compositions used for similar practical applications. The data summarized below illustrates that an extrusion coating composition of the present invention provides an extruded coating composition useful on the interior or exterior coating of a food or beverage container.

In particular, a coating composition for a metal container must demonstrate excellent adhesion and flexibility because metal containers are manufactured by first coating flat sheets of the metal substrate, then forming the coated sheets into a desired shape. Coatings having poor adhesion properties can separate from the metal substrate during the shaping process. A lack of adhesion, therefore, can adversely affect the ability of the cured coating composition to inhibit corrosion of the metal substrate. A present extrusion coating composition exhibits an excellent adhesion to a metal substrate, and, therefore, a coating can be extruded onto a metal substrate, and the metal substrate subsequently can be deformed without adversely affecting continuity of the coating film.

The extruded coating compositions also have excellent flexibility. Flexibility is an important property of a polymeric coating because the metal substrate is coated prior to stamping or otherwise shaping the metal substrate into a desired metal article, such as a metal container. The

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coated metal substrate undergoes severe deformations during the shaping process, and if a coating lacks sufficient flexibility, the coating can form cracks or fractures. Such cracks result in corrosion of the metal substrate because the aqueous contents of the container have greater access to the metal substrate. Metal substrates coated with a present extrusion coating composition were deformed into the shape of a metal can. No cracks or fractures were observed. In addition, as previously described, an extruded coating provided by an extrusion coating composition of the present invention is sufficiently adherent to the metal substrate, and remains sufficiently adherent during processing into a metal article, and, therefore, further enhances corrosion inhibition.

The tests summarized below demonstrate that a present extruded coating composition maintains adhesion to the metal substrate, is flexible, is sufficiently hard, and, therefore, is scratch and mar resistant, resists blush, and resists chemical attack. Such a combination of advantages are necessary, or at least desirable, in a coating applied to the interior of food and beverage containers.

The above-described advantages made an extrusion coating composition of the present invention useful for application on the interior or extrusion surface of a variety of metal articles, such as for the interior of metal containers for foods and beverages. A present extrusion coating composition is especially useful as a coating on a metal container that holds taste-sensitive foods or beverages.

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ages, like beer, because the extruded coating composition is essentially free of components that affect the taste of the food or beverage.

The tests performed on metal substrates  
5 coated with an extrusion coating composition of the present invention are well known to persons skilled in the art and are summarized as follows:

DOWFAX Test (Crosshatch Test)

Coated samples were immersed in a boiling  
10 1.67% aqueous solution of DOWFAX 2A1 surfactant for 15 minutes, rinsed in hot water, and dried. The samples then were crosshatched, taped, and rated for adhesion according to the following system:

0--perfect  
15 1--very slight pickoff from edges of squares  
2--slight pickoff (1-2%)  
3--moderate pickoff (2-50%)  
4--severe pickoff (>50%)  
5--very severe, crosshatching removes the coating.

20 The samples also were rated for blushing as follows:

0--perfect  
1--very slight haze on surface  
2--slight cloudy appearance  
3--moderate cloudy appearance  
25 4--very cloudy and dull appearance, possible discoloration.

The blush resistance test demonstrates the ability of an extruded coating to resist attack by a hot detergent solution. Adhesion is tested by the  
30 crosshatch adhesion test wherein razor blades make

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perpendicular crosshatch patterns in an applied coating. Adhesive tape is applied to the crosshatch patterns, then the adhesive tape is removed at a 90° angle in a fast movement. The amount of extruded  
5 coating remaining as the metal substrate then is determined.

#### MSE Test

Coated samples are immersed in equal parts of 4% (v/v) acetic acid, 6% (v/v) lactic acid, and  
10 6% (wt/v) NaCl for 15 minutes at 100°C. The samples are rated as in the above-described DOWFAX<sup>®</sup> test.

#### Hot Water Test

Coating samples were immersed in water for 30 minutes at 65°C. The samples were rated as in  
15 the DOWFAX test.

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Processing Test Solutions	
Solution D	Demineralized water
Solution S <sup>1</sup>	40 g concentrated acetic acid 24 g gelatin 24 g sodium chloride 0.4 g crystalline sodium sulfide ( $\text{Na}_2\text{S} \cdot 9 \text{H}_2\text{O}$ ) q.s. water to about 800 ml
Solution R <sup>1</sup>	16 g citric acid crystals 3.2 g vitamin C (ascorbic acid) q.s. water to about 800 ml
5      Solution O <sup>1</sup>	16 g citric acid crystals 0.2 g $\text{H}_2\text{O}_2$ hydrogen peroxide (30% sol.) 0.8 g $\text{NH}_4\text{NO}_3$ ammonium nitrate q.s. water to about 800 ml

<sup>1</sup> The test solutions D, S, R, O have been chosen for cans containing a wide variety of food filling; these tests are conducted for 1 hour at 121°C.

#### Water Pasteurization

10                      After immersion in 180°F water for 30 minutes, the coated panels were tested for 25 lb. reverse impact, blush, and pencil hardness.

#### Retort Test

15                      The retort test was performed to evaluate the resistance and adhesion of coatings under food processing conditions (90 minutes @ 250°F and 15 psi).



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4-Corner Cup

This is a shallow, drawn can body of approximately rectangular shape. Each of the four corners is curved, and each curved corner has a different diameter. The 4-Corner Cup is prepared from a metal substrate having a coating applied thereon before the can body is formed.

Mi (Lactic Acid), Cy (Cysteine) and NaCl/HAC (Sodium Chloride/Acetic Acid) Tests

A coated substrate is formed into a 4-Corner Cup container, then a test solution is added to the 4-Corner Cup and held at 120°C for one hour. The lactic acid solution is a 1% aqueous lactic acid solution. The cysteine solution contains 0.45 g cysteine and about 10 g of phosphate per liter of aqueous solution. The NaCl/HAC solution contains 2% sodium chloride and 3% acetic acid in water.

Civo-Test

A 4-Corner Cup container is placed in a larger container, and the larger container is filled with a 3% aqueous acetic acid solution. The large container is heated to 70°C and held for two hours. The container then is cooled, and stored for 10 days at 40°C. The 4-Corner Cup container then is inspected for defects.

Examples 1 through 20 illustrate extrusion coating compositions containing blends of a first

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and second polyester having Tg's that differ by at least 5C°, either containing or free of an optional modifying polymer. Examples 21-29 illustrate extrusion coating compositions containing blends of PET and PBT polyesters, and blends of PET and PBT polyesters with a copolyester, each containing and free of a modifying resin. Examples 30 and 31 illustrate pigmented extrusion coating compositions.

The properties of extruded coating compositions resulting from the extrusion coating compositions of Comparative Examples A and B and of Examples 1-31 are set forth in the following Table 1. In general, the results summarized in Table 1 show PET and PBT polyesters improve the adhesion of a copolyester to a metal substrate (Examples 1-20). Accordingly, a modifying resin, which promotes adhesion, can be excluded from the extrusion coating composition. Examples 21-30 show that blends of polyesters gave good film properties, and that including a low amount of a copolyester improved performance, e.g., less blushing was observed. The ability to use a polyester, like PET or PBT, has the benefits of lowering the cost of the composition without adversely affecting extruded coating composition performance, and providing the ability to design extrusion coating compositions having a viscosity suitable for specific application apparatus and methods.

Table 1										
		Comp. Ex. A	Comp. Ex. B	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	
Film Thick- ness	(microns)	12-16	9-12	12	10-15	8-12	8-13	9-13	8-14	
Cross Hedge	(GT)	0	3	1	1	0	0	0	2	
Dur-O-Test	(grams)	1400	1200	2000	1800	1500	1500	2000	1500	
Wedge Bend	(%)	100	100	100	m/c <sup>1</sup>	m/c	m/c	100	100	
Four Corner Cup		O.K.	O.K.	O.K.	m/c	O.K.	m.c	O.K.	O.K.	
Hot Water 30 min. at 65°C	GT	0	0	1	0	0	0	0	0	
	Blushing	0	0	0	0	0	0	0	0	
MSE Test 15 min. at 100°C	GT	0	0	1	0	0	0	0	2	
	Blushing	0	0	0	0 m/c	0	0	0	0	
Boiling Water 30 min.	Wedge Bend	100	100	100	0 m/c	0 m/c	0 m/c	100	90	
	Four Corner Cup	2	1	0	0 m/c	0 m/c	0 m/c	0	0	
Sterilization Water 1 hr. at 121°C	Wedge Bend	100	100	100	0 m/c	0 m/c	0 m/c	100	100	
	Four Corner Cup	1	1	0	0 m/c	0 m/c	0 m/c	0	0	

Table 1

		Comp. Ex. A	Comp. Ex. B	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6
Sterilization 1 hr. at 121°C GT/Blushing	D GT/Blushing	0/0	0/0	0/0	0/0 m/c	1/0	0/0	0/0	0/0
	S GT/Blushing	0/0	0/0	0/0	0/0 m/c	0/0	0/0	0/0	0/0
	R GT/Blushing	0/0	5/0	1/0	0/0 m/c	5/0	5/0	5/0	5/0
	O GT/Blushing	0/0	5/0	1/0	1/0 m/c	5/0	5/0	5/0	5/0
Sterilization 1 hr. at 128°C GT/Blushing	Lactic Acid	0/1	1/1	0/1	0/0 m/c	1/1	1/2	0/2	3/0
	Acetic acid/NaCl	0/0	0/0	0/1	0/1 m/c	1/2	0/1	0/1	0/0

1) m/c=micro cracks

Table 1

	Ex. 7	Ex. 8	Ex. 9	Ex. 10	Ex. 11	Ex. 12	Ex. 13
Film Thickness (microns)	11-16	5-11	10-13	9-12	10-15	10-17	8-15
Cross Hedge (GT)	0	0	0	0	0	0	0
Dur-O-Test (grams)	2000	1800	1800	1800	1800	1800	2000
Wedge Bend (°)	100	m/c	m/c	m/c	100	100	100
Four Corner Cup	O.K.	m/c	m/c	m/c	O.K.	O.K.	O.K.
Hot Water 30 min. at 65°C	0	0	0	0	0	0	0
Blushing	2	0	1	3	1	1	0
MSE Test 15 min. at 100°C	0	0	0	0	0	0	0
Blushing	2	1	0	1	0	0	2
Boiling Water 30 min.	100	0 m/c	0 m/c	0 m/c	100	100	100
Four Corner Cup	2	1 m/c	4	4	2	1	3
Wedge Bend	100	0 m/c	0 m/c	0 m/c	100	100	100
Sterilization Water 1 hr. at 121°C	2	1 m/c	4	4	1	1	3

Table 1											
		Ex. 7	Ex. 8	Ex. 9	Ex. 10	Ex. 11	Ex. 12	Ex. 13			
Sterilization 1 hr. at 121°C GT/Blushing	D GT/Blushing	0/2	0/1	1/2	0/2	0/1	0/1	0/2			
	S GT/Blushing	0/2	0/0	1/2	0/3	0/1	0/2	0/2			
	R GT/Blushing	4/2	0/0	2/2	4/2	5/1	5/1	0/3			
	O GT/Blushing	2/2	0/0	2/2	5/2	5/1	5/1	0/3			
	Lactic Acid	0/3	0/1	2/2	1/2	0/1	0/2	0/4			
Sterilization 1 hr. at 128°C GT/Blushing	Acetic acid/NaCl	0/3	0/2	2/1	1/2	0/1	0/2	0/3			

Table 1

	Ex. 14	Ex. 15	Ex. 16	Ex. 17	Ex. 18	Ex. 19	Ex. 20
Film Thickness (microns)	5-11	7-13	9-12	8-10	10-17	10-12	11-16
Cross Hedge (GT)	0	0	0	0	0	0	0
Dur-O-Test (grams)	2000	2000	1800	1900	1800	1800	1800
Wedge Bend (°)	100	100	m/c	m/c	100	100	100
Four Corner Cup	O.K.	O.K.	m/c	m/c	O.K.	O.K.	O.K.
Hot Water 30 min. at 65°C	0	0	0	0	0	0	0
Blushing	0	0	3	0	1	1	0
GT	0	0	0	0	0	0	0
Blushing	0	9	1	0	0	0	0
Wedge Bend	100	100	0 m/c	0 m/c	80	100	100
Four Corner Cup	1	0	4	4	1	1	1
Wedge Bend	100	0 m/c	0 m/c	0 m/c	90	100	100
Four Corner Cup	1	0	3	4	1	1	1

Table 1

		Ex. 14	Ex. 15	Ex. 16	Ex. 17	Ex. 18	Ex. 19	Ex. 20
Sterilization 1 hr. at 121°C GT/Blushing	D GT/Blushing	0/0	0/0	3/3	1/1	0/1	0/1	0/1
	S GT/Blushing	0/0	0/0	3/3	0/2	0/1	0/1	0/1
	R GT/Blushing	2/0	3/0	4/0	5/2	5/2	5/1	5/1
	O GT/Blushing	1/0	4/0	3/3	5/2	5/2	5/1	5/1
Sterilization 1 hr. at 128°C GT/Blushing	Lactic Acid	0/2	0/1	3/3	1/3	0/3	0/0	0/1
	Acetic acid/NaCl	0/1	0/1	2/3	1/1	0/2	0/1	0/1



Table 7

		Ex. 21	Ex. 22	Ex. 23	Ex. 24	Ex. 25	Ex. 26
Film Thickness	(microns)	6-10	8-13	8-12	5-10	10-13	9-13
Cross Hedge	(GT)	0	0	0	0	0	0
Dur-O-Test	(grams)	2000	1800	1800	1800	1800	1800
Wedge Bend	(%)	m/c	m/c	m/c	m/c	m/c	m/c
Four Corner Cup		O.K.	m/c	m/c	m/c	m/c	m/c
Hot Water 30 min. at 65°C	GT	0	0	0	0	0	0
	Blushing	0	0	1	0	2	3
MSE Test 15 min. at 100°C	GT	0	0	0	0	1	0
	Blushing	0	0	1	0	1	2
Boiling Water 30 min.	Wedge Bend	0 m/c	0 m/c	0 m/c	0 m/c	70	0 m/c
	Four Corner Cup	0 m/c	2	3	0 m/c	3	4
Sterilization Water 1 hr. at 121°C	Wedge Bend	0 m/c	0 m/c	0 m/c	0 m/c	90	100
	Four Corner Cup	0 m/c	1	2	1 m/c	3	4

Table 7

		Ex. 21	Ex. 22	Ex. 23	Ex. 24	Ex. 25	Ex. 26
Sterilization 1 hr. at 121°C GT/Blushing	D GT/Blushing	0/0	0/0	1/2	1/0	1/2	1/3
	S GT/Blushing	1/0	1/1	0/2	0/0	1/1	1/3
	R GT/Blushing	1/0	2/0	2/2	5/0	5/2	2/4
	O GT/Blushing	2/0	2/0	2/2	5/0	5/2	2/4
	Lactic Acid	1/0	1/0	1/3	1/0	4/2	0/4
Sterilization 1 hr. at 128°C GT/Blushing	Acetic acid/NaCl	0/0	0/0	1/2	1/0	5/2	0/4

Table 7

	Ex. 27	Ex. 28	Ex. 29	Ex. 30	Ex. 31
Film Thickness (microns)	8-11	7-11	10-12	8-15	5-11
Cross Hedge (GT)	0	0	0	0	0
Dur-O-Test (grams)	1600	1700	1800	2000	2000
Wedge Bend (%)	m/c	m/c	m/c	100	100
Four Corner Cup	O.K.	m/c	m/c	O.K.	O.K.
Hot Water 30 min. at 65°C	0	0	0	0	0
Blushing	0	0	1	0	0
MSE Test 15 min. at 100°C	0	0	0	0	0
Blushing	0	0	1	2	0
Boiling Water 30 min.	0 m/c	0 m/c	0 m/c	100	100
Four Corner Cup	0 m/c	2	4	3	1
Wedge Bend	0 m/c	0 m/c	0 m/c	100	100
Sterilization Water 1 hr. at 121°C	0 m/c	1	3	3	1

Table 7

		Ex. 27	Ex. 28	Ex. 29	Ex. 30	Ex. 31
Sterilization 1 hr. at 121°C GT/Blushing	D GT/Blushing	1/0	0/0	1/2	0/2	0/0
	S GT/Blushing	0/0	1/0	1/2	0/2	0/0
	R GT/Blushing	5/0	5/0	2/2	0/3	2/0
	O GT/Blushing	5/0	5/0	2/1	0/3	1/0
	Lactic Acid	1/2	1/1	1/3	0/4	0/2
Sterilization 1 hr. at 128°C GT/Blushing	Acetic acid/NaCl	0/1	1/1	1/3	0/3	0/1

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Obviously, many modifications and variations of the invention as hereinbefore set forth can be made without departing from the spirit and scope thereof, and, therefore, only such limitations  
5 should be imposed as are indicated by the appended claims.

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WHAT IS CLAIMED IS:

1. A composition comprising:

(a) about 50% to about 100%, by total weight of the composition, of a blend of polyesters comprising (i) a first polyester having a weight average molecular weight of about 10,000 to about 80,000 and a glass transition temperature of greater than 45°C to about 100°C, and (ii) a second polyester having a weight average molecular weight of about 10,000 to about 70,000 and a glass transition temperature of about -10°C to about 45°C, wherein the T<sub>g</sub> of the first polyester is about 5°C to about 60°C higher than the T<sub>g</sub> of the second polyester;

(b) 0% to about 25%, by total weight of the composition, of a modifying resin selected from the group consisting of an epoxy or phenoxy resin having an epoxy equivalent weight of about 500 to about 15,000, an acrylic resin having a weight average molecular weight of about 15,000 to about 100,000, a polyolefin resin having a weight average molecular weight of about 15,000 to about 1,000,000, and mixtures thereof;

(c) 0% to about 50%, by total weight of the composition, of an inorganic filler; and

(d) 0% to about 4%, by total weight of the composition, of a flow control agent; and

(e) 0% to about 50%, by total weight of the composition, of a second modifying polymer,

said composition in the form of an extruded film.

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2. The composition of claim 1 wherein the first polyester and the second polyester are present in a weight range of about 9 to 1 to about 1 to 9.

3. A method of coating a metal substrate comprising:

(a) heating the metal substrate to a temperature of about 60°C to about 300°C to provide a preheated metal substrate;

(b) heating a solid, thermoplastic coating composition to a sufficient temperature to melt the coating composition and provide a molten coating composition, said coating composition comprising:

(i) about 50% to about 100%, by total weight of the composition, of a blend of polyesters comprising (A) a first polyester having a weight average molecular weight of about 10,000 to about 80,000 and a glass transition temperature of greater than 45°C to about 100°C, and (B) a second polyester having a weight average molecular weight of about 10,000 to about 70,000 and a glass transition temperature of about -10°C to about 45°C, wherein the T<sub>g</sub> of the first polyester is about 5°C to about 60°C higher than the T<sub>g</sub> of the second polyester;

(ii) 0% to about 25%, by total weight of the composition, of a modifying resin selected from the group consisting of an epoxy or phenoxy resin having an

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epoxy equivalent weight of about 500 to about 15,000, an acrylic resin having a weight average molecular weight of about 15,000 to about 100,000, a polyolefin resin having a weight average molecular weight of about 15,000 to about 1,000,000, and mixtures thereof;

(c) extruding the molten coating composition onto a surface of the preheated metal substrate to provide a layer of molten coating composition about one to about 40 microns thick on the preheated metal substrate and provide a coated metal substrate; and

(d) heating the coated metal substrate at a temperature of about 120°C to about 550°C for about 5 to about 30 seconds.

4. The method of claim 3 further comprising the step of allowing the coated metal substrate to cool between steps (c) and (d).

5. The method of claim 3 wherein the thermoplastic coating composition further comprises:

(iii) 0% to about 50%, by total weight of the composition, of an inorganic filler; and

(iv) 0% to about 4%, by total weight of the composition, of a flow control agent.



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6. The method of claim 3 wherein the thermoplastic coating composition further comprises 0% to about 50%, by total weight of the composition, of a second modifying polymer.

7. The method of claim 6 wherein the second modifying polymer is a thermoplastic polymer.

8. The method of claim 6 wherein the second modifying polymer is a thermoset polymer.

9. The method of claim 3 wherein the metal substrate is selected from the group consisting of aluminum, tin-free steel, tinplate, steel, zinc-plated steel, zinc alloy-plated steel, lead-plated steel, lead alloy-plated steel, aluminum-plated steel, aluminum alloy-plated steel, and stainless steel.

10. The method of claim 3 wherein the coating composition is heated in step (b) to a temperature of about 180°C to about 350°C.

11. The method of claim 10 wherein the coating composition is heated to a maximum of 100°C above a melting point of the coating composition.

12. The method of claim 3 wherein the coating composition is free of organic solvents.

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13. The method of claim 3 wherein the first polyester and the second polyester are present in a weight range of about 9 to 1 to about 1 to 9.

14. The method of claim 3 wherein the Tg of the first polyester is about 15C° to about 35C° higher than the Tg of the second polyester.

15. The method of claim 3 wherein the coating composition comprises about 60% to about 85%, by total weight of the composition, of a polyester.

16. The method of claim 3 wherein the first and second polyesters have a melt viscosity of about 200 to about 3000 Pa.s and a softening point of about 120°C to about 200°C.

17. The method of claim 3 wherein the first and second polyesters have an acid number of 0 to about 150 mg KOH/g and a hydroxyl number of 0 to about 150 mg KOH/g.

18. The method of claim 3 wherein the first and second polyesters have a melt viscosity of about 250 to about 2000 Pa.s.

19. The method of claim 3 wherein the first and second polyesters have a melt flow index of about 800 g/10 min at 200°C or about 5 g/10 min. at 280°C.

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20. The method of claim 3 wherein the first and second polyesters comprise condensation product of (i) a dicarboxylic acid or an esterifiable derivative of a dicarboxylic acid, and (ii) an aliphatic diol, wherein at least 60 mol % of the dicarboxylic acid or dicarboxylic acid derivative is an aromatic dicarboxylic acid.

21. The method of claim 20 wherein the aromatic dicarboxylic acid is selected from the group consisting of phthalic acid, isophthalic acid, terephthalic acid, a naphthalene dicarboxylic acid, and mixtures thereof.

22. The method of claim 3 wherein the first and second polyesters comprise the reaction product of (i) a dicarboxylic acid or an esterifiable derivative of a dicarboxylic acid, and (ii) a low molecular weight epoxy resin having an EEW of about 150 to about 500.

23. The method of claim 3 wherein the first and second polyesters are selected from the group consisting of a polyethylene terephthalate, a polybutylene terephthalate, a polyethylene naphthanate, a polybutylene naphthanate, a copolyester, a polytrimethylene terephthalate, a polytrimethylene naphthanate, and mixtures thereof.

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24. The method of claim 3 wherein the coating composition comprises about 2% to about 20%, by total weight of the composition, of a modifying resin.

25. The method of claim 3 wherein the modifying resin comprises an epoxy resin having an epoxy equivalent weight of about 2000 to about 8000.

26. The method of claim 3 wherein the epoxy resin is a solid material containing an average of about 1.5 to about 2.5 epoxy groups per molecule of the epoxy resin.

27. The method of claim 3 wherein the epoxy resin is a solid material containing an average of about 2.5 to about 6 epoxy groups per molecule of the epoxy resin.

28. The method of claim 3 wherein the epoxy resin comprises a mixture of an epoxy resin having about 1.5 to about 2.5 epoxy groups per molecule of the epoxy resin and an epoxy resin having about 2.5 to about 6 epoxy groups per molecule of the epoxy resin.

29. The method of claim 3 wherein the epoxy resin is an aromatic epoxy resin.

30. The method of claim 29 wherein the aromatic epoxy resin is based on bisphenol A or bisphenol F.

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31. The method of claim 3 wherein the modifying resin is an acrylic resin having a weight average molecular weight of about 20,000 to about 80,000.

32. The method of claim 3 wherein the acrylic resin is a homopolymer or a copolymer of homopolymer and copolymers of acrylic acid, methacrylic acid, esters of acrylic acid, esters of methacrylic acid, acrylamides, and methacrylamides.

33. The method of claim 3 wherein the modifying resin is a polyolefin resin having a weight average molecular weight of about 25,000 to about 750,000.

34. The method of claim 3 wherein the polyolefin resin is a homopolymer or a copolymer of ethylene, propylene, ethylene, propylene blends, 1-butene, and 1-pentene.

35. The method of claim 3 wherein the polyolefin comprises a functionalized olefin.

36. The method of claim 3 wherein the molten coating composition is extruded onto opposing surfaces of the preheated metal substrate.

37. The method of claim 3 wherein the layer of molten coating composition is about 2 to about 30 microns thick.

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38. The method of claim 3 wherein the layer of molten coating composition is about 1 to about 10 microns thick.

39. The method of claim 3 wherein the molten coating composition is extruded onto the preheated metal substrate by an extruder comprising a screw and die, wherein the preheated metal substrate is moving relative to the die.

40. The method of claim 38 wherein the screw is a single screw, a conrotatory twin screw, or a counter rotatory twin screw.

41. The method of claim 3 wherein the heating step is performed at 180°C to about 450°C for about 15 to about 20 seconds.

42. The method of claim 5 wherein the coating composition comprises 0% to about 30% by total weight of the composition of an inorganic filler.

43. The method of claim 5 wherein the inorganic filler is selected from the group consisting of clay, mica, aluminum silicate, fumed silica, magnesium oxide, zinc oxide, barium oxide, calcium sulfate, calcium oxide, aluminum oxide, magnesium aluminum oxide, zinc aluminum oxide, magnesium titanium oxide, iron titanium oxide, calcium titanium oxide, and mixtures thereof.

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44. The method of claim 5 wherein the flow control agent comprises an acrylic resin.

45. The method of claim 3 wherein the thermoplastic coating composition further comprises a pigment, an organic dye, or a mixture thereof.

46. The method of claim 6 wherein the second modifying polymer is selected from the group consisting of a carboxylated polyester, a carboxylated polyolefin, a polyamide, a fluorocarbon resin, a polycarbonate, a styrene resin, an acrylonitrile-butadiene-styrene resin, a chlorinated polyether, a urethane resin, and mixtures thereof.

47. The method of claim 6 wherein the second modifying polymer is capable of providing a coated metal substrate having a nongloss appearance.

48. A metal article formed from the coated metal substrate of claim 3.

49. A metal article formed from the coated metal substrate of claim 4.

50. The article of claim 48 wherein the article is a can body, a can end, or a metal closure for a container.

## INTERNATIONAL SEARCH REPORT

International Application No

PCT/IS 00/06738

A. CLASSIFICATION OF SUBJECT MATTER  
IPC 7 C09D167/02 B05D1/26

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C09D B05D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

WPI Data, PAJ, CHEM ABS Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

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X	WO 97 44394 A (THE DEXTER CORP ) 27 November 1997 (1997-11-27) cited in the application claims 1-49; examples 1,11-41 page 7, line 31 -page 8, line 14 ---	1-50
X	CHEMICAL ABSTRACTS, vol. 129, no. 11, 14 September 1998 (1998-09-14) Columbus, Ohio, US; abstract no. 137031, XP002142169 abstract & JP 10 166531 A (TORAY IND., INC.) 23 June 1998 (1998-06-23) --- -/--	1,2

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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## INTERNATIONAL SEARCH REPORT

International Application No

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